

Date: Friday, 08/08/2008 11:24:18 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: PRELIM.
Job Number	: 41077		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D412777011
This Issue	: 08/08/2008 S.O. No. :	Drawing Number	: D412-777-011
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 15/08/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 PICK PACKING KIT:



5000/08/08

Paper work D412-777-011 CHG 001

2.0	D2182B	Rubber Cushion
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Comment: Qty.: 12.0000 f(s)/Unit Total: 12.0000 f(s)
 Rubber Cushion
 26 X D2182B055 (5.5")

Q (8)

B31777

B39986

SC

3.0	D2274	Radius Block
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Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)
 Radius Block

Q (20)

B32857

B39238

SY

4.0	D2521	Bearpaw 205
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Bearpaw 205

35062

8/8/8

(K)

SC

5.0	D2529	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)
 Washer

B32025

8/8/8

(K)

SC

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2947

Clamp



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
Clamp

B330386

B36826

SP

7.0

D37951

Ski Fwd



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Ski Fwd

B40674

SP

8.0

D37953

Ski Mid



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Ski Mid

B40623

8/8/8

SP

9.0

D3796041

FWD WEARPLATE WELDMENT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
FWD WEARPLATE WELDMENT

B41111

8/8/19

SP

10.0

D3796043

AFT WEARPLATE WELDMENT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
AFT WEARPLATE WELDMENT

B41110

8/8/4

SP

11.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bolt

M105143

SP

12.0

AN417A

Bolt



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)
Bolt

M107321

SP

13.0

AN9704

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

M108377

8/8/8

SP

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN960JD416

Washer



M108161

(18)



20

Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Washer

M16941

M105906

50

15.0

MS21042L4

Nut



M105054

(20)



32

(14)

Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Nut

M15924

(8)

8/8/8

M107478

50

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



ENGINEERING APPROVAL



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 08/08/20

08.08.20

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PACKAGE PER PPP

41077

08/08/20

(40)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/09

Job Completion



POSITIVE RECALL

EFFECTIVE 08.08.08 AUTH

RELEASED DATE

08.09.08

СЛУЖБА
РАБОТА

- 3.1.4 Position the D3695-1 FWD Ski Section and D3796-041 Wearplate as shown in Figure 1.
- 3.1.3 The D2521 Bearpaw, D3795-1 Forward Ski Section and D3795-3 Mid Ski Section may be relieved to clear the wearshoe mounting screws provided the relief leaves 0.375in thickness.
- 3.1.4 Attach the D2947 Clamps, D2182B055 Rubber Cushion and associated hardware in the holes as shown in Figure 3 and Section A-A.
CAUTION: The torque on the nuts should be limited to 20 in-lb.
- 3.1.5 Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4 bolts with longer or shorter AN4 bolts, if required.
- 3.1.6 Lower the aircraft

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-777-011	72.0 lb 32.7 kg	0.0 in 0.0 m	0.0 lb-in 0.0 m-kg	115 in 2.93 m	8280 in-lb 95.8 m-kg

5.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D412-777-011	BEARPAW INSTALLATION
26	D2182B055	RUBBER CUSHION
52	D2274	RADIUS BLOCK
2	D2521	BEARPAW
12	D2529	WASHER
26	D2947	CLAMP
2	D3795-1	FWD SKI SECTION
2	D3795-3	MID SKI SECTION
2	D3796-041	FWD WEARPLATE
2	D3796-043	AFT WEARPLATE
8	AN4-12A	BOLT
52	AN4-17A	BOLT
8	AN970-4	WASHER
52	AN960JD416	WASHER
60	MS21042L4	NUT (OR MS21042-4)

PRELIMINARY ISSUE
 108.08.20

- 3.1.3 The D2521 Bearpaw, D3795-1 Fwd Ski Section and D3795-3 Mid Ski Section may be relieved to clear the wearshoe mounting screws provided the relief leaves 0.375in thickness.
- 3.1.4 Attach the D2947 Clamps, D2182B055 Rubber Cushion and associated hardware in the holes as shown in Figure 1 and Detail A, B and C.
CAUTION: The torque on the nuts should be limited to 20 in-lb.
- 3.1.5 Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4 bolts with longer or shorter AN4 bolts, if required.
- 3.1.6 Lower the aircraft

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-777-011	72.0 lb	0.0 in	0.0 lb-in	123.7 in	8906 in-lb
Ski Installation	32.7 kg	0.0 m	0.0 m-kg	3.14 m	102.7 m-kg

5.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D412-777-011	SKI INSTALLATION
26	D2182B055	RUBBER CUSHION
52	D2274	RADIUS BLOCK
2	D2521	BEARPAW
12	D2529	WASHER
26	D2947	CLAMP
2	D3795-1	FWD SKI SECTION
2	D3795-3	MID SKI SECTION
2	D3796-041	FWD WEARPLATE
2	D3796-043	AFT WEARPLATE
8	AN4-12A	BOLT
52	AN4-18A 7/16 1/2	BOLT
8	AN970-4	WASHER
52	AN960JD416	WASHER
60	MS21042L4	NUT (OR MS21042-4)